

Work Order ID 58828

Wednesday, May 19, 2010 1:03:06 PM



Page 1

Item ID: D3639-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 5/19/2010 Start Qty: 8.00

Required Date: 5/26/2010 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-5-19 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3639

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3639

☐ Dwg Rev: A

☐ Prog Rev: A

☐ 2-

Debur if necessary

2024.650

10-6-1

10-6-1

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-6-1

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8.066602

10-6-1

10-6-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 03639-1 PAR #: _____ Fault Category: Procl eng cover NCR: Yes No DQA: [Signature] Date: 10/06/02
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 10/06/09

NCR: <u>58028</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/06/02</u>	<u>170</u>	Found qty x 6 parts with tabs cut inside the 0.098" hubs R.C. leading out on outside of hubs	<u>[Signature]</u>	- Scrap + Destroy qty x 6 AND Replace in <u>112291</u> + 3	<u>[Signature]</u> <u>10-6-02</u>	<u>[Signature]</u> <u>10/6/02</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>10/6/02</u>
		Program error, Pressure from main	<u>[Signature]</u>	- Fix Program	<u>[Signature]</u> <u>10-06-02</u>	<u>[Signature]</u> <u>10/6/02</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>10/6/02</u>

NOTE: Date & initial all entries

Work Order ID 58828

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Page 2

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Required Date: 5/26/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

NC BRAKE

0.00

0.00

SP 10/06/07

(6)

Memo

Brake NC

Form as per Dwg D3639

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

SP 10/06/07

(6)

-1

Memo

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

= 7m. / 10/06/07

(6X)

Memo

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58828

Wednesday, May 19, 2010 1:03:06 PM

Page 3

Item ID: D3639-1

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Revision ID:

Item Name: Doubler

Start Date: 5/19/2010 Start Qty: 8.00

Required Date: 5/26/2010 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: ST244A 0.00

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

10/06/09 *[Signature]*
M/10-6-08
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 19, 2010 1:03:11 PM

Page 1

Work Order ID: 58828



Parent Item: D3639-1



Parent Item Name: Doubler

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP Rev:A New Issue 07-07-20 JLM

Verified By:EC

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	33.9947	0.239	2.2		



2024-T3 .050 sheet



B 10-6-1

Location

Loc Qty

Loc Code

MAT22

33.9947

111381

30.9

112291

2.7

113189

0.3947

112291

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	58828
Description: Doubler		Part Number:	D3639-1
Inspection Dwg: D3639 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.625	x			
Ø0.191	+0.005/-0.001	.192	x			
Ø0.098	+0.004/-0.001	.099	x			
0.69	+/-0.030	.687	y			
1.59	+/-0.030	1.592	x			
2.49	+/-0.030	2.493	y			
3.39	+/-0.030	3.389	x			
3.990	+/-0.010	3.990	y			
4.990	+/-0.010	4.990	y			
5.19	+/-0.030	5.192	y			
6.99	+/-0.030	6.993	x			
8.64	+/-0.030	8.646	x			
0.45	+/-0.030	.453	y			
0.710	+/-0.010	.705	x			
2.000	+/-0.010	2.000	x			
2.75	+/-0.030	2.749	x			
3.55	+/-0.030	3.549	x			
4.00	+/-0.030	4.003	x			
2.000	+/-0.010	2.002	y			
2.590	+/-0.010	2.589	x			

Measured by:	HB	Audited by:		Prototype Approval:	N/A
Date:	10-6-1	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

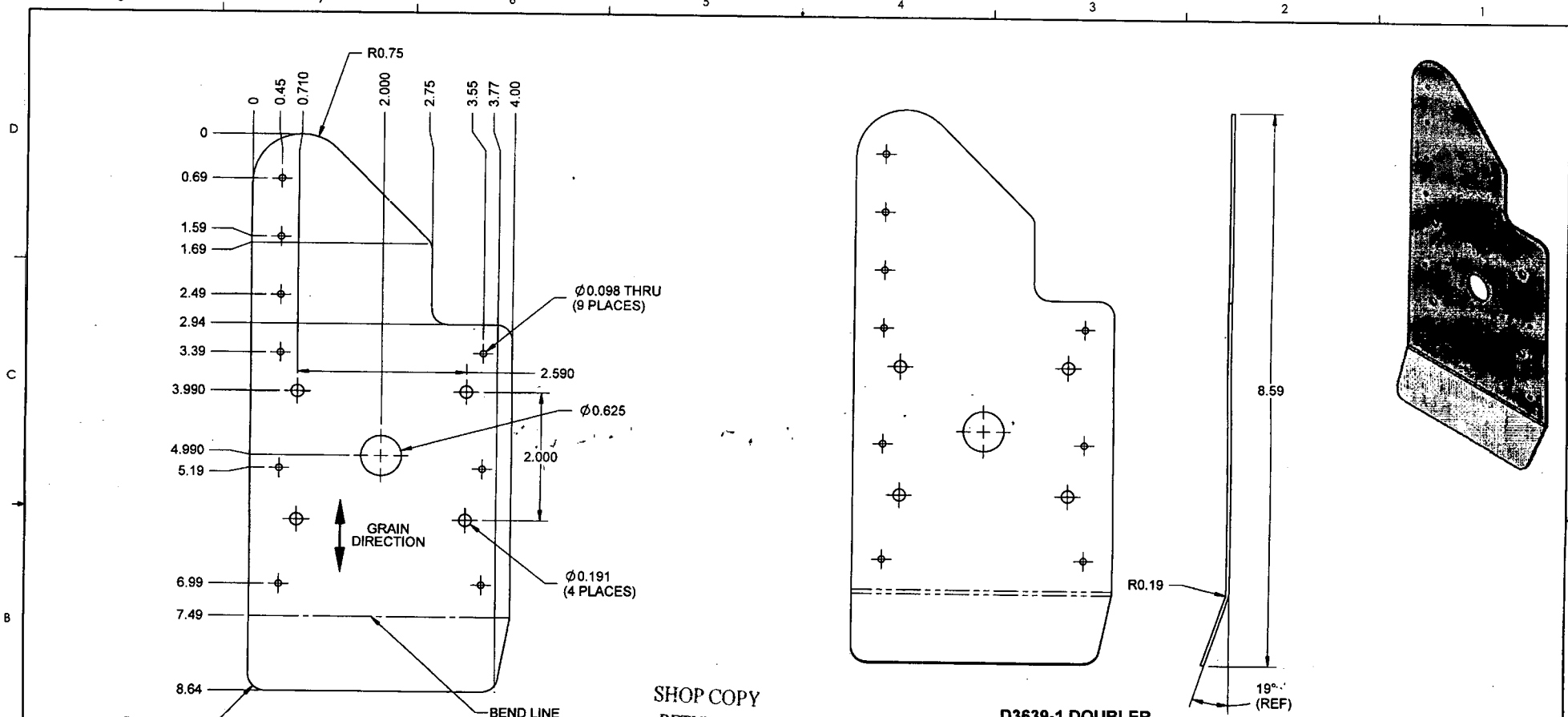
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3639-1F FLAT PATTERN
(D3639-2F OPPOSITE)

D3639-1 DOUBLER
(WAS GENEVA P/N G10604-3)
D3639-2 OPPOSITE
(WAS GENEVA P/N G10604-6)

RELEASED
07.07.27

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58825
RS10-5-1a

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.14 lbs

A		NEW ISSUE; REPLACES G10604		LE	07.07.27
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.		DRAWING NO.		REV. A	
		D3639		SHEET 1 OF 2	
		TITLE		SCALE	
		DOUBLER		2:3	
DATE		COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			
07.07.27					

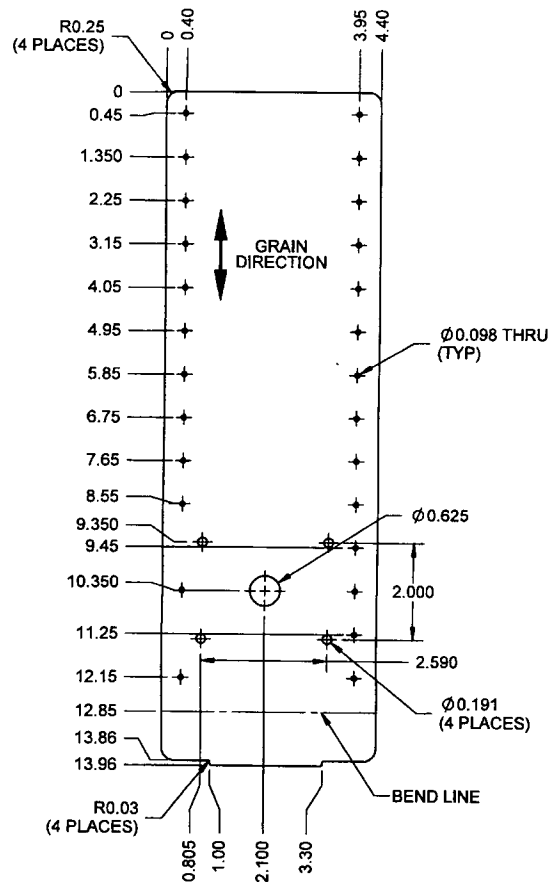
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

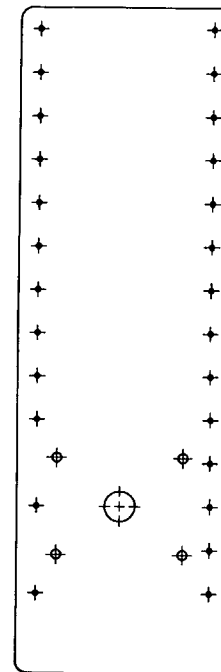
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

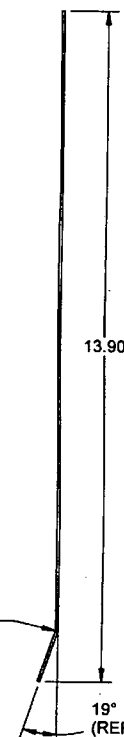
NOTE: Date & initial all entries



D3639-3F FLAT PATTERN
(D3639-4F OPPOSITE)



D3639-3 DOUBLER
(WAS GENEVA P/N G10604-4)
D3639-4 OPPOSITE
(WAS GENEVA P/N G10604-5)



W/058828

RELEASED
07.09.07

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	B	D3639	SHEET 2 OF 2
APPROVED	10	TITLE	SCALE
DE APPR.	#	DOUBLER	2:5
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11		11						

NOTE: Date & initial all entries